

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025358**Date Inspected:** 23-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	John Pagliero		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	S.A.S. components	

Bridge No: 34-0006**Summary of Items Observed:**

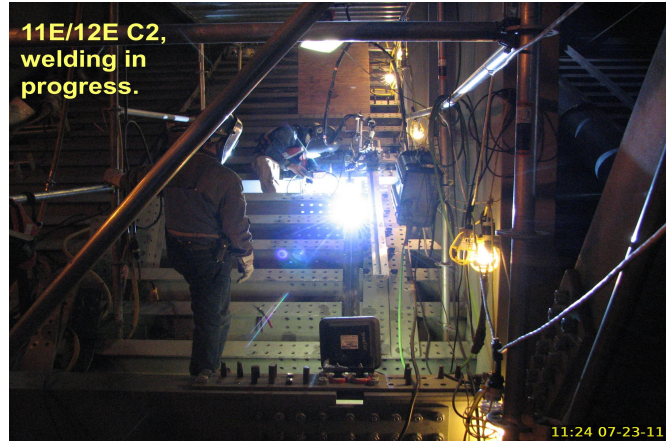
The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

1) Field Splice welding at OBG 11E/12E

1)The QAI observed ABF personnel working at field splice 11E/12E welds C1 and C2. The QAI noted that all work in being performed on the interior of the structure. The QAI noted that Quality Control Inspector (QCI) John Pagliero is monitoring this work. The QAI observed that at weld C1, Hua Qiang Huang, ID 2930, and Xiao Jian Wan, ID 9677, are using gas shielded Flux Cored Arc Welding (FCAW-G) to weld the 1st side of the complete joint penetration (CJP) field splice weld. The QAI observed that at weld C2, James Zhen, ID 6001, and Wai Kit Lai, ID 2953, are also using FCAW-G to weld the CJP field splice weld. The QAI noted that at each weld, the 2 operators are using the same welding machine, as it is set onto a track and as the weld progresses, the operators switch control of the machine. The QAI noted that each location is utilizing the same welding procedure specification (WPS) ABF-WPS-D15-3042B-1. The QAI made random observations of the welding parameters and noted that the welding at each location appeared to be within the ranges listed on the approved WPS. The QAI noted that at the end of this shift, the welding at each location was approximately 25% completed. See the attached photos.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations of work to the QAI Joselito Lizardo and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer